

## Replacement of traction sheaves with cylindrical bore

### 1) Removal:

- Dismounting the existing traction sheave by blasting the hub or pulling with a hydraulic cylinder.
  - Blasting the traction sheave can be done with a 1 mm circular saw for example.
    - Use the circular saw to cut the hub of the traction sheave in the area where the slot for the key is located. It is the thinnest part and you can't damage the shaft if you enter on the key.

### 2) Preparation / Cleaning:

- Preparation of the shaft:
  - Sharpening the entire shaft with sandpaper grain size 120 or higher. **ATTENTION!** Always in the longitudinal direction of the shaft.
  - To clean the area where the key is located please use a file with the sandpaper or remove the key for cleaning process.
  - **WARNING!** The range of the bevel at the end of the traction sheave shaft is particularly to treat. With dismantling the existing traction sheave a ridge results which you can only feel with the nail of your finger (see picture)
    - The transition from bevel to shaft has to be burred with a file in longitudinal direction.
    - Same procedure with sandpaper and file.
  - After finishing all above named steps clean the shaft with Thinner or similar.
  - If present, please measure the diameter of the shaft with a micrometer. The fit of the bore you will find at a label on the traction sheave.
  - As last step lubricate the entire shaft with special grease for hydraulic assembling ("ALTEMP Q NB 50 for example)
- Preparation of the bore / traction sheave:
  - For your own safety please sharp the bore of the traction sheave with sandpaper grain sizes 120 or higher in longitudinal direction too. Please start from the side of the small offset in the bore.
    - This step is necessary because we can't rule out small damages caused by handling and transport of the goods.
  - Clean bore with Thinner or similar.
  - Lubricate the complete bore of the traction sheave with grease too ("ALTEMP Q NB 50 for example)

### 3) Assembling:

- Assembling with hydraulic cylinder
  - **ATTENTION!** Please make sure that traction sheave and traction sheave shaft have the right temperature (ambient temperature).
  - Push the traction sheave with remote side where the offset at the bore is clean, straight flushed on the shaft and defer as much as possible by hand.
  - Insert thread bar in the center hole of the shaft and add a cover on the traction sheave hub.
  - Push hollow shaft hydraulic cylinder on the bar and lock with a nut
  - Push traction sheave as far as it is in the right position or flush with shaft.
  - **ATTENTION!** In case of irregular rough-running during the assembling process or excessive pressure STOP immediately and check cause. At best pull off traction sheave immediately to avoid or minimize damages.

